



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D350-591-122
Job Sheet 175544



Part No: D350-591-122

Job Qty: 2 ea

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 4/20/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG D2351-042 REV E, IIN-D350-591 REV H IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		4/19/18	0.00	0.00	Start Up Large Fab-4		DC 2018-04-06
110	Large Fab	2 pcs		4/19/18	0.00	1.60	Large Fab 8		DC 2018-04-06
120	CNC Bend Skid tubes	2 pcs		4/19/18	0.38	0.69	CNC Bend Skid tube		DC 2018-04-06
122	QC	2 pcs		4/19/18	0.00	0.00	QC5		DC 10-04-11
126	Large Fab	2 pcs		4/19/18	0.00	2.25	Large Fab 8		SLU
130	QC	2 pcs		4/19/18	0.00	0.00	QC5		CPC
140	Large Fab	2 pcs		4/19/18	0.00	1.67	Large Fab 2		SL
150	QC	2 pcs		4/19/18	0.00	0.00	QC9		CPC
160	QC	2 pcs		4/19/18	0.00	0.00	QC5		CPC
170	HandFinish	2 pcs		4/19/18	0.00	0.46	HandFinish1		SA 18-04-16
180	QC	2 pcs		4/19/18	0.00	0.00	QC7-2		CPC
190	Large Fab	2 pcs		4/19/18	0.00	1.60	Large Fab 2		SLU
220	QC	2 pcs		4/19/18	0.00	0.00	QC10		CPC
230	QC	2 pcs		4/19/18	0.00	0.00	QC5		CPC
240	HandFinish	2 pcs		4/19/18	0.00	0.38	HandFinish1		SA 18-04-18
250	Powdercoat	2 pcs		4/19/18	0.00	0.41	Powdercoat1		BR 18-04-18
260	HandFinish	2 pcs		4/20/18	0.00	0.38	HandFinish3		BEB 18-04-18
270	QC	2 pcs		4/20/18	0.00	0.00	QC3		EB
280	Packaging	2 pcs		4/20/18	0.00	0.00	Packaging1-3		DAS
290	QC	2 pcs		4/20/18	0.00	0.00	QC4		58
295	DC	2 pcs		4/20/18	0.00	0.00	DC		9-89
300	Packaging	2 pcs		4/20/18	0.00	0.00	Packaging3-1		DAS
310	QC21-FG	2 Ea		4/20/18	0.00	0.00	QC21		58

Part Op 110 - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

Descriptions: 120 - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.

126 - ***BUFF AND REMOVE BENDING MARKS WITHIN .005", if deeper see engineer***

140 - 1-Bevel Fwd and Aft end for welding

190 - 1-Rivet Leg Assembly as per Dwg D2351

250 - START TIME: 11:00 Temp 800° Finish 11:20. M138760

295 - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

300 - Identify and pack for shipping as per PPP D350-591-121

310 - 3-Do not Grind top edge Flush

wing walk M138761

Plex 4/6/18 10:27 AM dart.leroux.jason

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	1 Ea (.5 ea)	90-Start up Operation	5014552
D2850-2	End Cap	2 Ea (1 ea)	126-Large Fab	F150658
D2582	Hi-Skid Step Leg Assembly	2 Ea (1 ea)	190-Large Fab	
D2673-34	End Plate	2 Ea (1 ea)	190-Large Fab	5042088
MS20600-AD4W3	Cherry Rivet	32 Ea (16 ea)	190-Large Fab	
AN3-37A	Bolt	4 Ea (2 ea)	280-Packaging	
AN4-13A	Bolt	2 Ea (1 ea)	280-Packaging	
AN4-16A	Bolt	4 Ea (2 ea)	280-Packaging	
D2230-1	Mounting Lug	2 Ea (1 ea)	280-Packaging	
D2230-3	Mounting Lug	2 Ea (1 ea)	280-Packaging	
D2732-030	Rubber Cushion - 3"	4 Ea (2 ea)	280-Packaging	
MS21042L3	Nut	4 Ea (2 ea)	280-Packaging	
MS21042L4	Nut	6 Ea (3 ea)	280-Packaging	
NAS1149D0363J	Washer	8 Ea (4 ea)	280-Packaging	
NAS1149D0463J	Washer	12 Ea (6 ea)	280-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	1	155	0
126-Large Fab	D2850-2	2	9	0
190-Large Fab	D2582	2	1	0
	D2673-34	2	25	0
	MS20600-AD4W3	32	395	0
280-Packaging	AN3-37A	4	90	0
	AN4-13A	2	900	0
	AN4-16A	4	214	0
	D2230-1	2	4	0
	D2230-3	2	154	0
	D2732-030	4	171	0
	MS21042L3	4	2,563	0
	MS21042L4	6	3,873	0
	NAS1149D0363J	8	2,883	0
	NAS1149D0463J	12	5,730	0

Part Specifications

Specifications could not be found.

Plex 4/6/18 10:27 AM dart.leroux.jason



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Container No: S058862



Part: D350-591-122

Job No: 175544

Serial No/Batch: S058862

Revision:

Inspector:

Date: 04/06/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002602	S062409	AN3-37A	Bolt	S041154	ST347	4
002602	S062408	AN4-13A	Bolt	S045860	ST344	2
002602	S062407	AN4-16A	Bolt	S041125	ST343	4
002602	S062406	D2230-1	Mounting Lug	S059886	ST521	2
002602	S062405	D2230-3	Mounting Lug	S051382	ST521	2
002602	S062404	D2732-030	Rubber Cushion - 3"	S044807	ST410	4
002602	S062403	MS21042L3	Nut	s038764	ST303	4
002602	S062402	MS21042L4	Nut	s045901	ST303	6
002602	S062401	NAS1149D0363J	Washer	s015269	ST263	8
002602	S062400	NAS1149D0463J	Washer	s045845	ST263	12

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Hell-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Hell-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Hell-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Hell-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Hell-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Hell-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Hell-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

Change Record

PAGE 1 OF 1

Part Number: D350-591-122

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, RH

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					